

Work Order ID 63033

Monday, October 18, 2010 1:00:28 PM



Page 1

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10/10/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

Deburr if necessary

B 10-10-20

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

4

10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Required Date: 10/26/2010 Req'd Qty: 4.00

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Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr if necessary.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

SB 10/10/22 (4)

SB 10/10/22

(4)

10/11/22 40 SP

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Page 3

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Item Name: Cabin Floor Protector

Start Date: 10/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22

mf

10-10-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 1:00:33 PM

Page 1

Work Order ID: 63033



Parent Item: D3574-1



Parent Item Name: Cabin Floor Protector

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,865.803	33.6	134.4672			
GE PLASTICS LEXAN SHEET													

10-10-20

Location

Loc Qty

Loc Code

MAT

1865.8038

115261

1865.8038

115261

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	63033
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	X		V B02	
7.37	+/-0.030	7.37	X		T B01	
10.75	+/-0.030	10.75	X		T	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	X		T	
44.75	+/-0.030	44.75	X		T	
49.11	+/-0.030	49.11	X		T	
51.11	+/-0.030	51.11	X		T	
53.51	+/-0.030	53.51	X		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	X		T	
10.75	+/-0.030	10.75	X		T	
11.06	+/-0.030	11.06	X		T	
14.75	+/-0.030	14.75	X		T	
25.50	+/-0.030	25.56	X		T	
25.75	+/-0.030	25.75	X		T	
26.00	+/-0.030	26.00	X		T	
32.87	+/-0.030	32.87	X		T	
38.81	+/-0.030	38.81	X		T	
44.75	+/-0.030	44.75	X		T	
45.00	+/-0.030	45.00	X		T	
48.25	+/-0.030	48.25	X		T	
58.38	+/-0.030	58.38	X		T	
61.25	+/-0.030	61.25	X		T	
64.13	+/-0.030	64.13	X		T	
64.63	+/-0.030	64.63	X		T	
66.50	+/-0.030	66.50	X		T	
7.50	+/-0.030	7.50	X		T	
9.50	+/-0.030	9.50	X		T	
10.38	+/-0.030	10.38	X		T	
10.88	+/-0.030	10.88	X		T	
14.50	+/-0.030	14.50	X		T	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43033
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	X		T B01	
18.75	+/-0.030	18.75	X		T	
24.13	+/-0.030	24.13	0		T	
26.50	+/-0.030	26.50	X		T	
30.50	+/-0.030	30.50	0		T	
33.88	+/-0.030	33.88	X		T	
39.50	+/-0.030	39.50	0		T	
40.25	+/-0.030	40.25	X		T	
43.50	+/-0.030	43.50	A		T	
43.83	+/-0.030	43.83	A		T	
46.60	+/-0.030	46.60	A		T	
7.63	+/-0.030	7.63	0		T	
11.00	+/-0.030	11.00	A		T	
11.50	+/-0.030	11.50	A		T	
16.75	+/-0.030	16.75	0		T	
19.00	+/-0.030	19.00	A		T	
22.50	+/-0.030	22.50	X		T	
30.75	+/-0.030	30.75	0		T	
32.63	+/-0.030	32.63	0		T	
32.75	+/-0.030	32.75	0		T	
35.13	+/-0.030	35.13	0		T	
36.50	+/-0.030	36.50	0		T	
40.00	+/-0.030	40.00	0		T	
41.88	+/-0.030	41.88	0		T	
43.63	+/-0.030	43.63	0		T	
0.125	+/-0.010	.131	X		V B02	

Measured by: IB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-10-20	Date: 10/10/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	[Signature]

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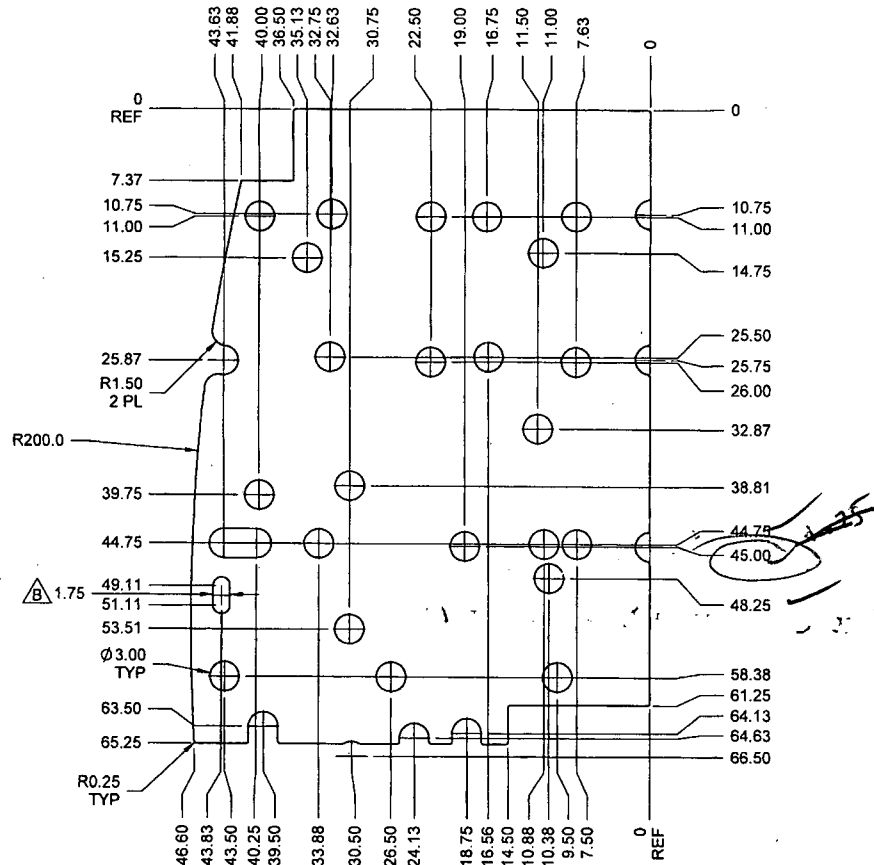
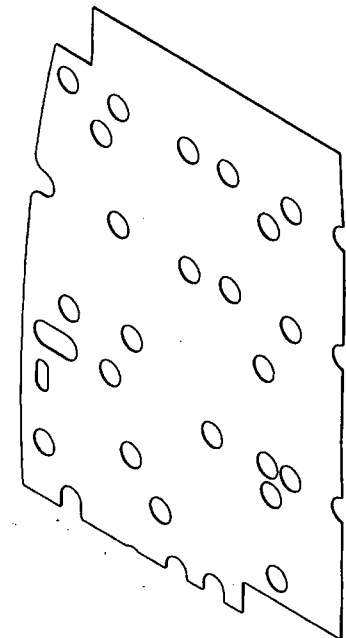
NOTE: Date & initial all entries

SHOP COPY

REL 3-10-18

UNCONTROLLED COPY
SUBJECT: D3574-1

NO. 63083
2801018



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

RELEASED
01/04/07

B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B
SHEET 1 OF 6
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

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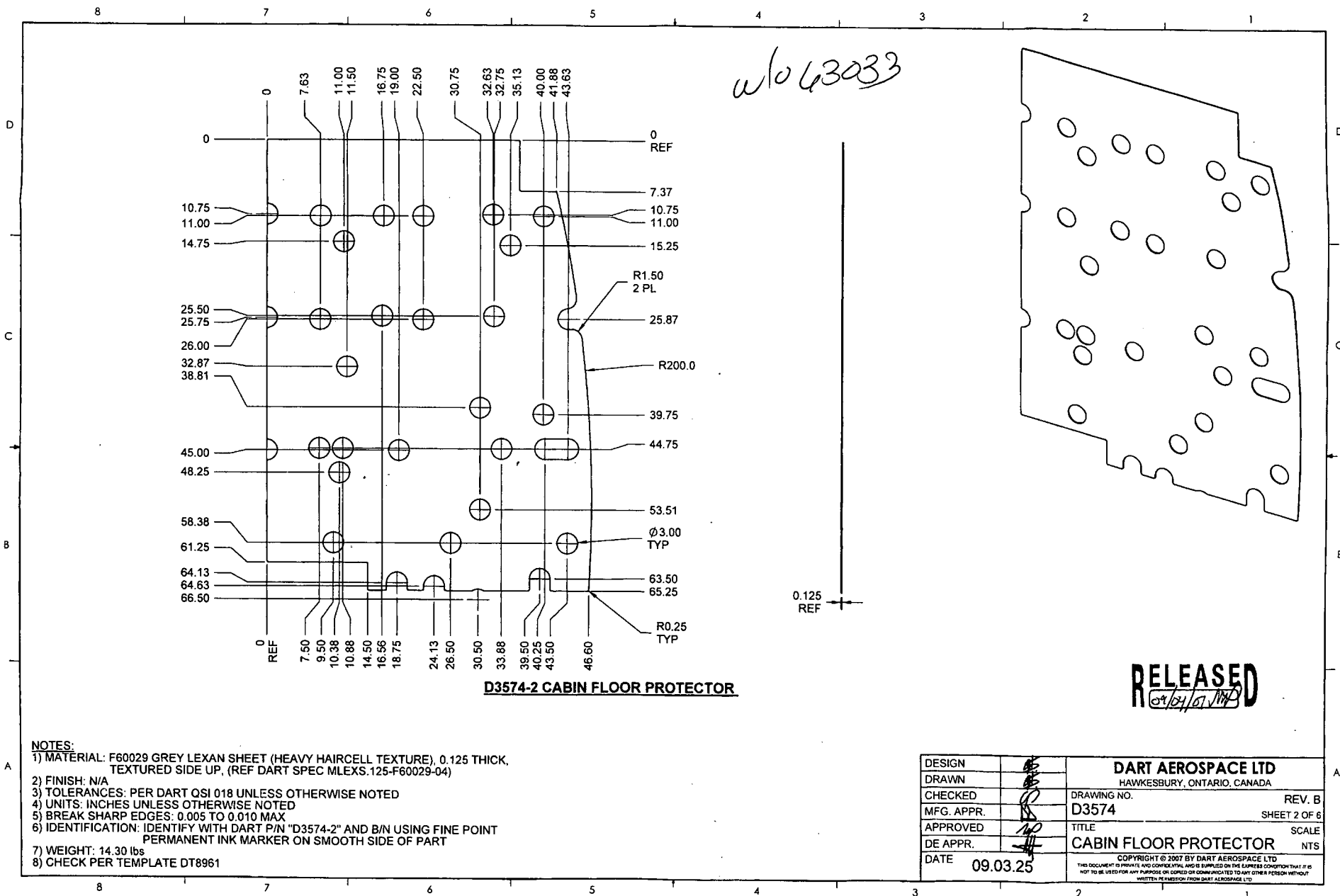
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



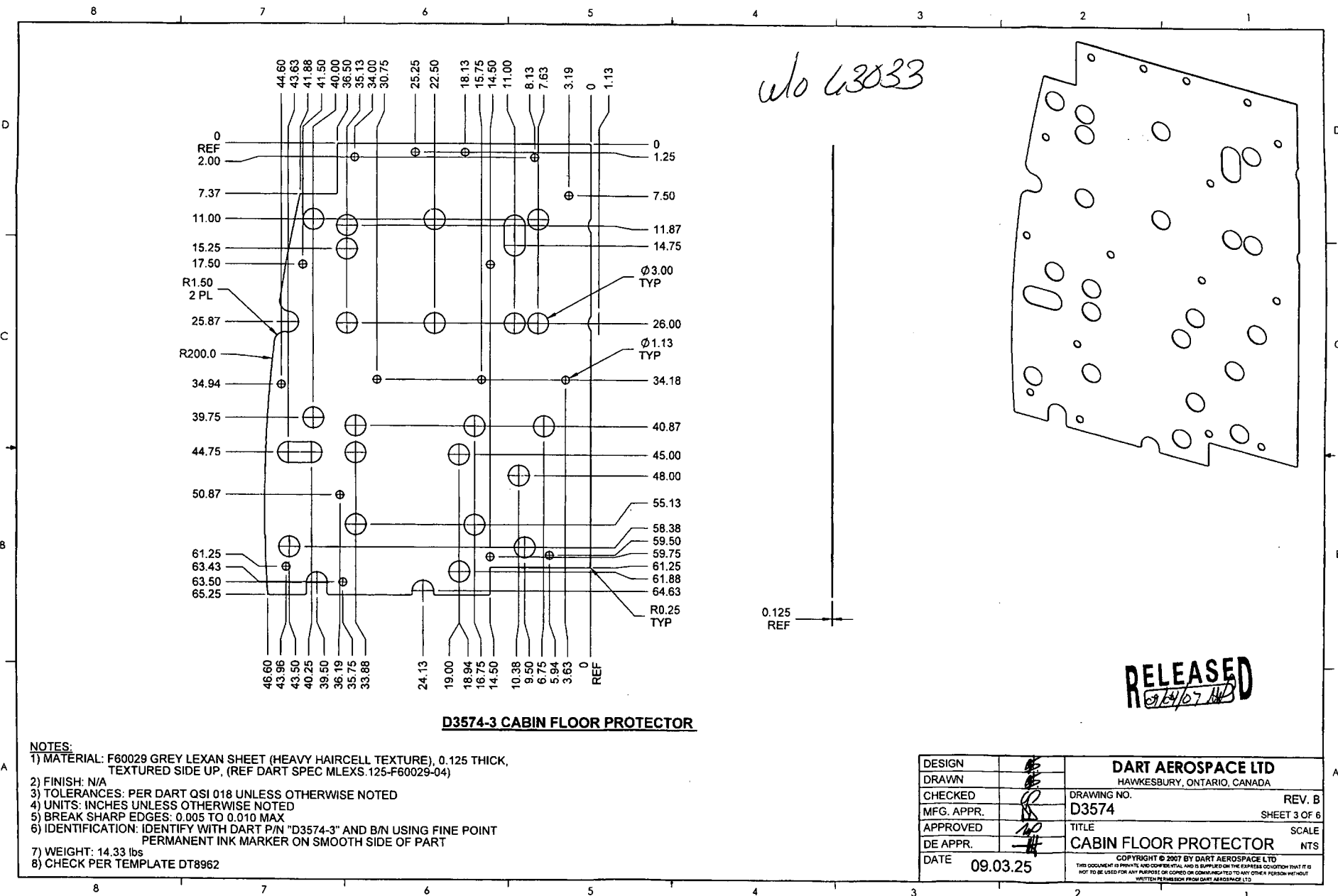
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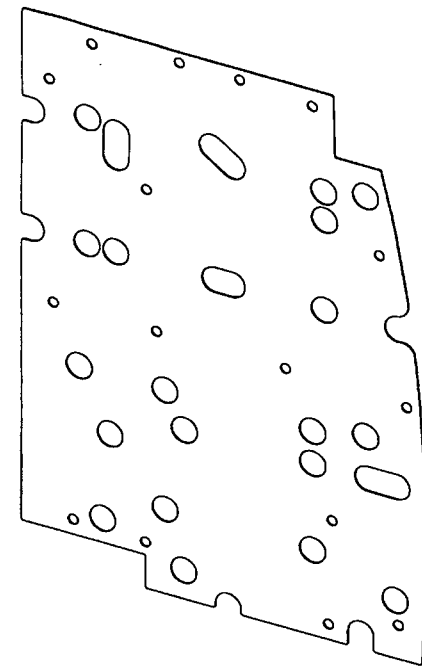
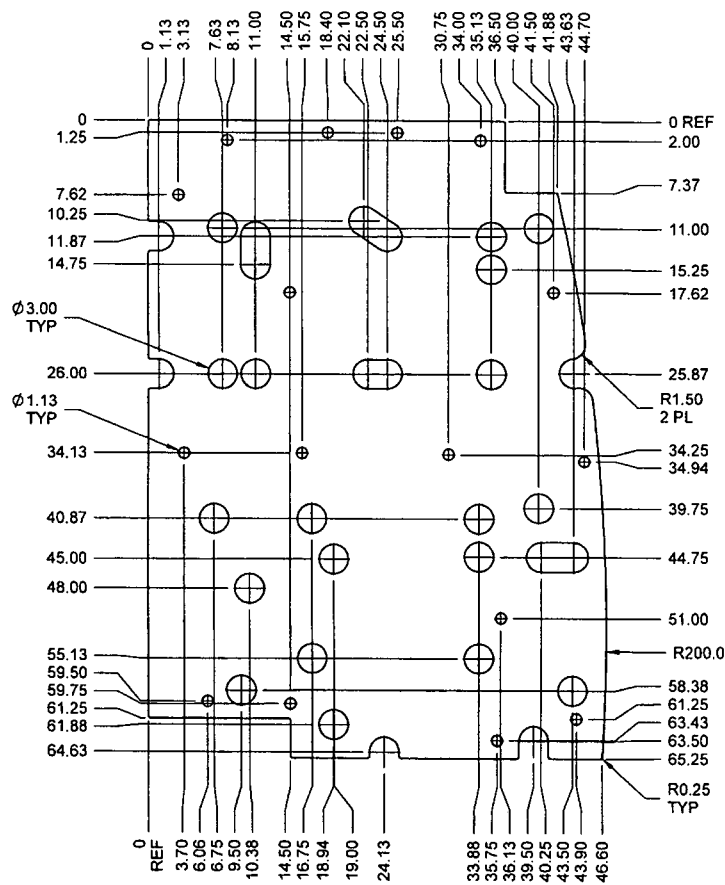
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NOTE: Date & initial all entries

W043033









RELEASED
9/27/07

D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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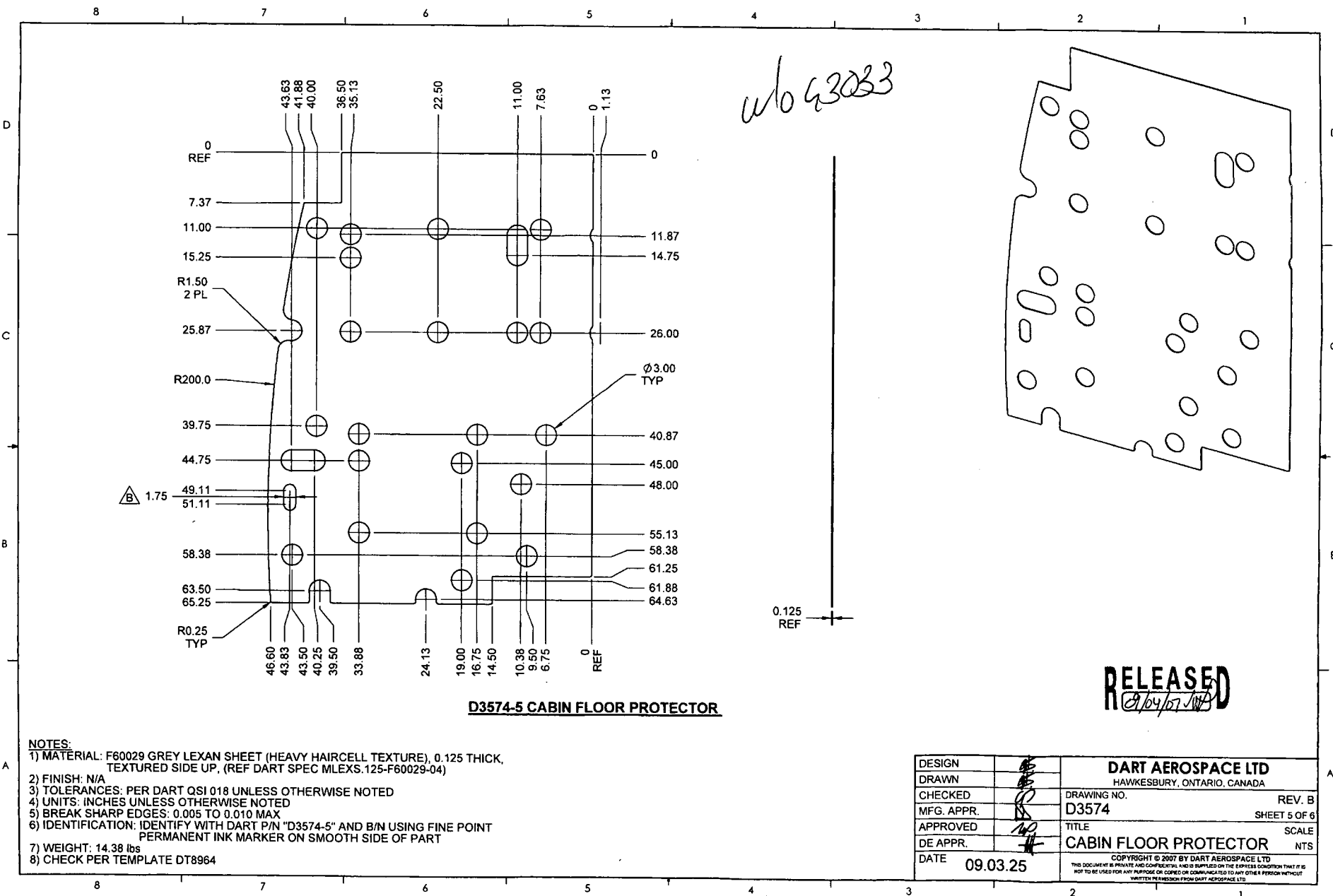
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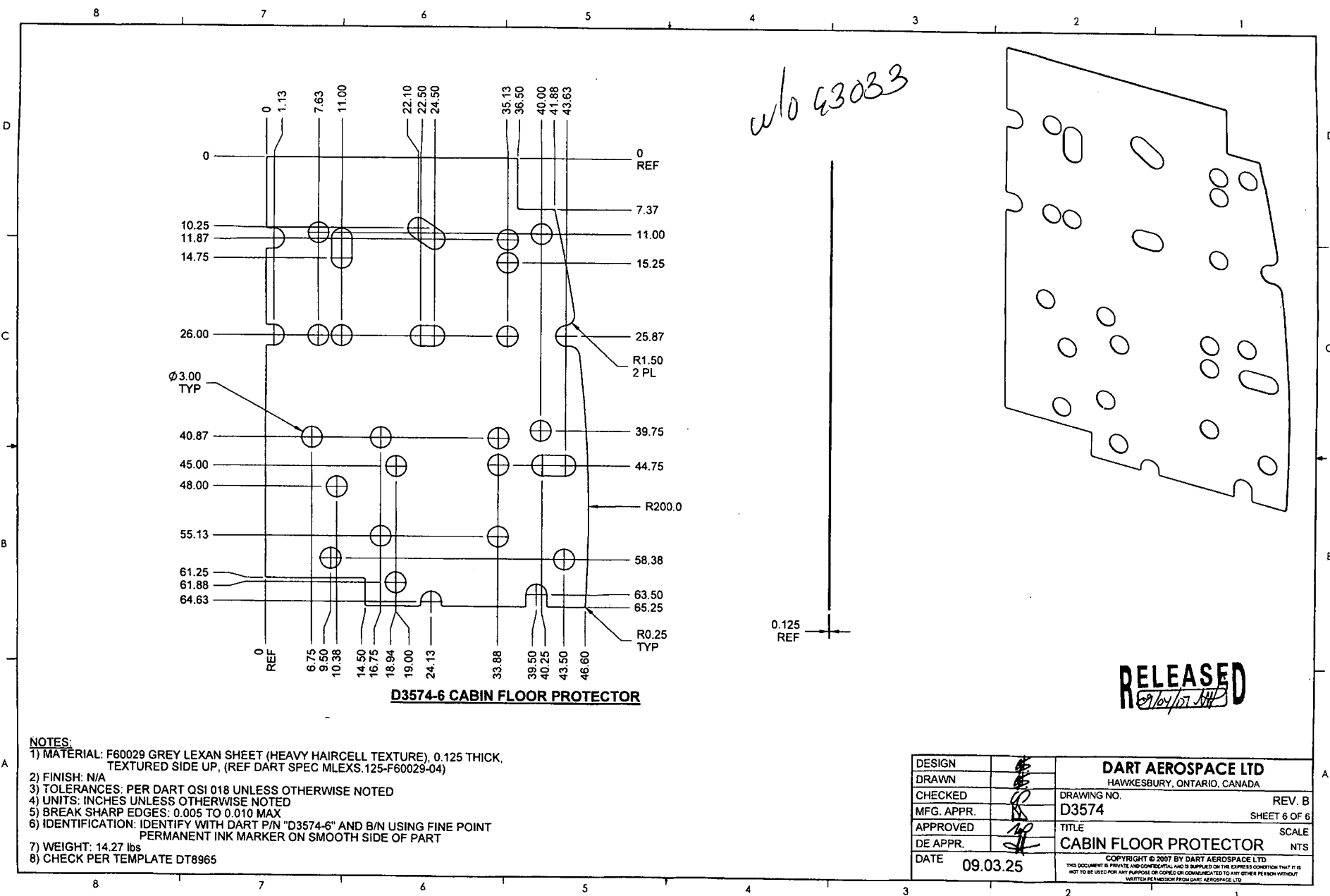
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